

Work Order ID 162211

Tuesday, May 30, 2017 8:13:21 AM

162211

Page 1

Item ID: D066-1003-011L08

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/31/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/21/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: **DAS** Date: **MAY 30 2017**

Tooling:

Date: _____

Run Start ***NR1***QC: **21**
9-89

Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D066-1003

B

MAY 30 2017**DAS****6****9-89**

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D066-1003-011L08 CHG002

DAS
27
9-89
JUN 13 2017

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89
JUN 08 2017

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.06

Quality Control

DAS
27
9-89
JUN 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 162211

Tuesday, May 30, 2017 8:13:21 AM

162211

Page 2

Item ID: D066-1003-011L08**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** R66 Cabin Floor Protector - Clear**Start Date:** 5/31/2017 **Start Qty:** 2.00 ***2*****Cust Item ID:****Required Date:** 6/21/2017 **Req'd Qty:** 2.00 ***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

Identify as per dwg & Stock Location: _____
Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D066-1003-011L08
Location : FG117

2

DAS
21
9-89

JUN 13 2017

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.20

DAS
21
9-89

JUN 14 2017

DAS
21
9-89

JUN 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, May 30, 2017 8:13:24 AM

Page 1

Work Order ID: 162211

162211

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/31/2017

Required Date: 6/21/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.02.05 NEW ISSUE DD VERF:JLM IPP Rev. B
14/07/02 Parts list updated. DL IPP REV:C 15.02.1 AS
PER IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3580-3 *D3580-3* Joggle Bracket DAS 27 9-89		Manufactured	No			110	Each	6.0000	6	12	6 9-89	JUN 08 2017	JAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST040				6					
				145423				6					
MS21059L3 *MS21059L3* Nut Plate DAS 27 9-89		Purchased	No			110	Each	95.0000	6	12	6 9-89	JUN 08 2017	JAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				27					
				M137412				27					
				ST301				68					
				M137587				38					
				M137659				30					
D4941-1L08 *D4941-1L08* Floor Protector, Fwd LH, (Clear) DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	2	6 9-89	JUN 08 2017	JAS 28 9-89
D4941-2L08 *D4941-2L08* Floor Protector, Fwd RH, (Clear) DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	2	6 9-89	JUN 08 2017	JAS 28 9-89
D4941-3L08 *D4941-3L08* Floor Protector, Aft LH, (Clear) DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	2	6 9-89	JUN 08 2017	JAS 28 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, May 30, 2017 8:13:24 AM

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Work Order ID: 162211

162211

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/31/2017

Required Date: 6/21/2017

Start Qty: 2.00

Required Qty: 2.00

D4941-4L08 Manufactured No

110 Each

0.0000 1 2

D4941-4L08

Floor Protector, Aft RH, (Clear)

AN525-10R8

Purchased No

110 Each

273.0000 6 12

AN525-10R8

Screw

Location

Loc Qty

Loc Code

ST329

273

m135058

273

MS20426AD3-4

Purchased No

110 Each

7,618.000 12 24

MS20426AD3-4

RIVET

Location

Loc Qty

Loc Code

GA

5932

m134294

1921

m136444

4011

ST312

1686

m134294

1686

**

16442

DAS 6

JUN 08 2017

DAS 28

**

DAS 6

JUN 06 2017

DAS 28

**

DAS 6

JUN 08 2017

DAS 28

DAS 27 9-89

DAS 27 9-89

12

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 162211

162211

Tuesday, May 30, 2017 8:13:21 AM

Item ID: D066-1003-011L08

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: R66 Cabin Floor Protector - Clear

Start Date: 5/31/2017 Start Qty: 2.00

Required Date: 6/21/2017 Req'd Qty: 2.00

2

2

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals:

Process Plan:

Date: MAY 30 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
11N-D066-1003	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL	0.00							
DC	Memo								
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D066-1003-011L08 CHG002								
110	Pick Kit	0.00							
110		0.00							
Packaging	Memo								
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120		0.06							
QC	Memo								
Quality Control									

CB (2) MAY 31 2017



Transport Canada Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH14-28

Issue No.: 1

Approval Date: June 20, 2014

Issue Date: June 26, 2014

Responsible Office: Prairie and Northern

Aircraft/Engine Type or Model: Robinson R66

Canadian Type Certificate or Equivalent: H-111

Description of Type Design Change: Interior Protector Kits

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of the Interior Protector Kits must be in accordance with Transport Canada Civil Aviation (TCCA) approved DART Aerospace Ltd. (DART) Installation Instructions IIN-D066-1003 Revision A, dated May 8, 2014 or later TCCA approved revision.

Maintenance of the Interior Protector Kits must be in accordance with TCCA accepted DART Instructions for Continued Airworthiness ICA-D066-1003 Revision 0, dated June 18, 2014 or later TCCA accepted revision.

Definition of the Type Design Change: TCCA approved DART Master Document List MDL-D066-1003 Revision A, dated June 20, 2014 or later TCCA approved revision.

Basis of Certification for Affected Areas: AWM Chapter 527, Change 527-8, dated June 30, 2009 (equivalent to 14 CFR Part 27 including amendments 27-1 through 27-44)..

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.

Scott W. Wales
For Minister of Transport

Canada

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the D066-1003-XXX kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1003-011L02 Cabin Floor Protector (Black Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-011L08 Cabin Floor Protector (Clear Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-013 Baggage Compartment Protectors	16.5 lb 7.5 kg	3.29 in 0.08 m	54 in-lb 0.60 m-kg	104.35 in 2.65 m	1721 in-lb 19.88 m-kg

5.0 PARTS LIST

Qty -011 L02	Qty -011 L08	Qty -013	Part Number	Description
X			D066-1003-011L02	CABIN FLOOR PROTECTORS (BLACK)
	X		D066-1003-011L08	CABIN FLOOR PROTECTORS (CLEAR)
		X	D066-1003-013	BAGGAGE COMPARTMENT PROTECTORS
1			D4941-1L02	FLOOR PROTECTOR, FWD LH
	1		D4941-1L08	FLOOR PROTECTOR, FWD LH
1			D4941-2 L02	FLOOR PROTECTOR, FWD RH
	1		D4941-2 L08	FLOOR PROTECTOR, FWD RH
1			D4941-3 L02	FLOOR PROTECTOR, AFT LH
	1		D4941-3 L08	FLOOR PROTECTOR, AFT LH
1			D4941-4 L02	FLOOR PROTECTOR, AFT RH
	1		D4941-4 L08	FLOOR PROTECTOR, AFT RH
		1	D4942-1	FLOOR PROTECTOR
		1	D4942-3	FORWARD WALL PROTECTOR
		1	D4942-7	LH WALL PROTECTOR
		1	D4942-9	DOOR PROTECTOR
		2	D4967-1	BRACKET
6	6		D3580-3	JOGGLE BRACKET
		3	D3580-5	JOGGLE BRACKET
		1	D5119-1	PLACARD
		1	D5120-1	PLACARD
6	6		AN525-10R8	SCREW
		10	AN525-10R9	SCREW
		8	CS62-1032-8CR	STUD, CLICK BOND
		3	AN970-3	WASHER
		8	MS21042-3	NUT, SELF LOCKING
		5	CB 200	3.5G ACRYLIC ADHESIVE
6	6	10	MS21059L3	NUTPLATE
12	12	20	MS20426AD3-4	RIVET